

60° centre holes

Types R, A, B, and C

DIN
332
Part 1

Zentrierbohrungen 60°, Form R, A, B und C

Supersedes November 1973 edition.

In keeping with current practice in standards published by the International Organization for Standardization (ISO), a comma has been used throughout as the decimal marker.

See Explanatory notes for connection with International Standards ISO 866 – 1975, ISO 2540 – 1973, and ISO 2541 – 1972 published by the International Organization for Standardization (ISO).

1 Scope and field of application

Dimensions in mm

This standard applies to unthreaded 60° centre holes for general engineering purposes.

Centre holes of type R, type A up to and including size 12,5 mm × 26,5 mm, and type B up to and including 10 mm × 21,2 mm are made with type R, A or B centre drills as specified in DIN 333.

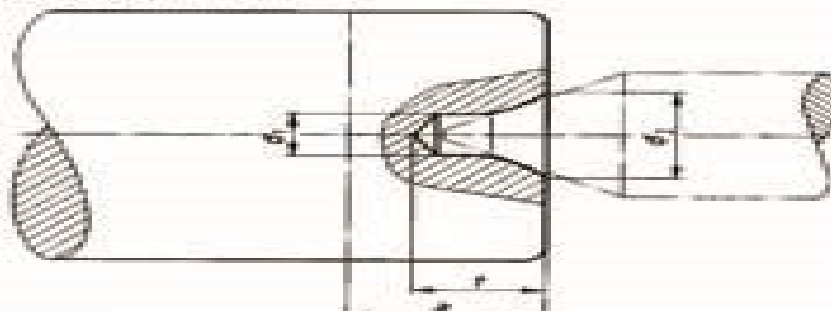
Type A centre holes above size 12,5 mm × 26,5 mm, type B centre holes above size 10 mm × 21,2 mm and type C centre holes are normally manufactured by means of two or more tools in different, successive operations. For the centring portion of type C centre holes up to and including size 12,5 mm × 26,5 mm or 10 mm × 21,2 mm, however, type A or type B centre drills as specified in DIN 333 may be used, since the centring portion is the same for types A, B and C.

Unspecified details of the centre holes made with centre drills result from the shape of the centre drill (see Explanatory notes).

See DIN 332 Part 2 for the determination of d_2 for a workpiece mass up to 28 000 kg.

2 Dimensions, designation

2.1 Type R, radius form, without protective chamfer



Designation of a radius form 60° centre hole without protective chamfer (R), with diameter $d_1 = 4$ mm and diameter $d_2 = 8,5$ mm:

Centre hole DIN 332 – R 4 × 8,5

Table 1.

d_1	d_2	r ¹⁾ Minimum	a ²⁾	d_1	d_2	r ¹⁾ Minimum	a ²⁾
0,5	1,06	1,4	2	● 3,15	6,7	5,8	9
0,8	1,7	1,5	2,5	● 4	8,5	7,4	11
● 1	2,12	1,9	3	● 5	10,6	9,2	14
● 1,25	2,65	2,3	4	● 6,3	13,2	11,4	18
● 1,6	3,35	2,9	5	● 8	17	14,7	22
● 2	4,25	3,7	6	● 10	21,2	18,3	28
● 2,5	5,3	4,6	7	12,5	26,5	23,6	36

● These sizes are specified in ISO 2541 – 1972.

For ¹⁾ and ²⁾, see table 2.

Continued on pages 2 to 5

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